



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D412-664-403
Job Sheet 185903



Part No: D412-664-403

Job Qty: 1 ea

Part Name: 412 Stainless Steel Aft Crosstubes - High



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/6/18

Job Tracking No:

Due Date: 11/27/18

Created By: Jesse White

Type: Stock

Description:

Note: D412-664-443 REV.B/ IIN-D212-664 REV.J IPP REV:A 13.10.25 NEW ISSUE DD VERF:JLM IPP Rev.B
17.06.26 As per Dwg/Chg/PAR16-545 DP Verify DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S134350



Part: D412-664-403

Job No: 185903

Serial No/Batch: S134350

Revision: B/J

Inspector:

Exp Date:

Instructions: TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA ST

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/27/18	0.00	0.00	Start Up Crosstubes-2		DPZ
110	CNC Bend Crosstubes	1 pcs		11/27/18	0.00	5.88	CNC Bend Crosstube		DPZ DAS
127	QC	1 pcs		11/27/18	0.00	0.00	QC15		38
128	Crosstubes	1 pcs		11/27/18	0.00	2.78	Crosstubes-2		GP 1-11-18
130	Crosstubes	1 pcs		11/27/18	0.00	2.78	Crosstubes-2		GP 18-12-05
140	QC	1 pcs		11/27/18	0.00	0.00	QC6		38
174	Outsource	1 pcs		11/27/18			SKY002-VC	POO41973	CG 18-12-7
176	Packaging	1 pcs		11/27/18	0.00	0.00	Packaging2		DEC 11 2018
178	QC	1 pcs		11/27/18	0.00	0.00	QC5		38
180	SprayPaint	1 pcs		11/27/18	0.00	2.70	Spray Paint		AB 18-12-7
190	QC	1 pcs		11/27/18	0.00	0.00	QC14		
200	Crosstubes	1 pcs		11/27/18	0.00	2.78	Crosstubes-2		AB 18-12-11
210	QC	1 pcs		11/27/18	0.00	0.00	QC5		38
220	Packaging	1 pcs		11/27/18	0.00	0.00	Packaging1-4		DEC 17 2018
230	QC	1 pcs		11/27/18	0.00	0.00	QC4		DEC 17 2018
240	Packaging	1 pcs		11/27/18	0.00	0.00	Packaging3-2		DEC 17 2018
245	DC	1 pcs		11/27/18	0.00	0.00	DC		38
250	QC21-FG	1 Ea		11/27/18	0.00	0.00	QC21		DEC 18 2018

Part Op 110 - Bend tube as per Dwg D412-664-443 using CNC bender program D412-664-443 ****USE (4) DT9824 SHIM BLOC
 Descriptions: TO CHECK STRAIGHTNESS****

127 - ***MARK CUT LINES***

128 - CUT TUBE AT HEIGHT ON FAI SHEET VERF HEIGHT 74.375 BY QC 15 LEVEL INSPECTOR _____
 VERF TWIST 245 BY QC15 LEVEL INSPECTOR _____

130 - 1- Drill Tube as per Dwg D412-664-443 Using DT8550/8551 Drill Jigs, Set-up drill table as per QSI 010 2 -Deburr 3- Engrave Part # and Batch # as per Dwg D412-664-443 4-Remove all marks from tube within limits of D412-664-443 DWG.

180 - ***USE AXALTA 230S PRE-TREATMENT AS PER QSI005*** AXALTA BATCH: 138021 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O
 ***VERIFY BY _____ PART # TO MATCH W/O ***MASK SCRIBE

B# & P# AND VERIFY*** 1-Prime inside & outside cross tube as per QSI 005 4.2 BATCH: 138962 2- Apply matte clear coat to underside of cross tube per QSI005 4.2 BATCH: 138875 3- MASK UNDERSIDE OF CROSSTUBE AS SHOWN ON DWG BEFORE PAINTING 4 -Paint Outside of Tube as per Dart QSI 005 4.2 BATCH: 138978 5-Remove masking

200 - 1- *****LAY DOWN CORSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MESURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** Install center support using scotch-weld DP460 per QSI 015, as per DWG. note 12. Install supports clamps as per Dwg D412-644-443. . ***ENSURE CLAMPS ARE ON TOP OF CROSSTUBE SUPPORT*** Torque clamps on support to 80-100 IN-LBS AS PER DWG. A/R scotch-weld DP460 BATCH #: 5004031 EXP DATE: 4/19 2- **IF NOT ALREADY PRESENT ON CHAFFING SHEILD.** Apply a thin coat of proseal 890 per QSI 015 on inside concave surface of chafing shield and let cure per manufacturer's instructions. Install prosealed chafing shield onto crosstube by applying a thin coat of proseal 890 onto crosstube. Be sure to eliminate any air gaps. Install and torque clamps on chafing shield to 40-50 IN-LBS AS PER DWG. A/R Proseal 890 Batch: 138976 EXP DATE: 6/19 AFTER FINISH CURE TIME 24H START CURE TIME: 18-12-11 FINISH CURE TIME: 18-12-12 PRIOR TO PACKAGING RE-CHECK TORQUE ON CLAMPS AFTER CURED FOR 24H.

210 - PRIOR TO PACKAGING RE-CHECK TORQUE ON CLAMPS AFTER CURED FOR 24H.

240 - Identify and pack for shipping as per PPPD412-664-443 Location: _____ PPP Rev: _____

245 - Photocopy bluefile & type labels per PPPD412-664-403 CHG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D412-664-443TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	5127064
D4910-1	Chaffing Shield	2 Ea (2 ea)	200-Crosstubes	
MS21920-26	Clamp	4 Ea (4 ea)	200-Crosstubes	
D5380-1	Support	1 Ea (1 ea)	200-Crosstubes	
D5380-3	Support Base	1 Ea (1 ea)	200-Crosstubes	
NAS1805-4P	Nut	8 pcs (8 ea)	200-Crosstubes	
NAS6704-21	Bolt	8 pcs (8 ea)	200-Crosstubes	
AN6-40A	3/8-24 Bolt X 3" Long	4 Ea (4 ea)	220-Packaging	541108
AN6-41A	Bolt	2 Ea (2 ea)	220-Packaging	5123684
MS21042L6	Nut	6 Ea (6 ea)	220-Packaging	5133196
NAS1149D0663J	Washer	18 Ea (18 ea)	220-Packaging	5093765

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D412-664-443TRN	1	0	0
200-Crosstubes	D4910-1 5097624	②	17	0
	D5380-1 5097633-1	①	0	0
	D5380-3 5096765	①	2	0
	MS21920-26 5043311	④	46	0
	NAS1805-4P 5043784	⑧	119	0
	NAS6704-21 5043791	⑧	136	0
220-Packaging	AN6-40A	4	102	0
	AN6-41A	2	47	0
	MS21042L6	6	326	0
	NAS1149D0663J	18	1,035	0

Part Specifications

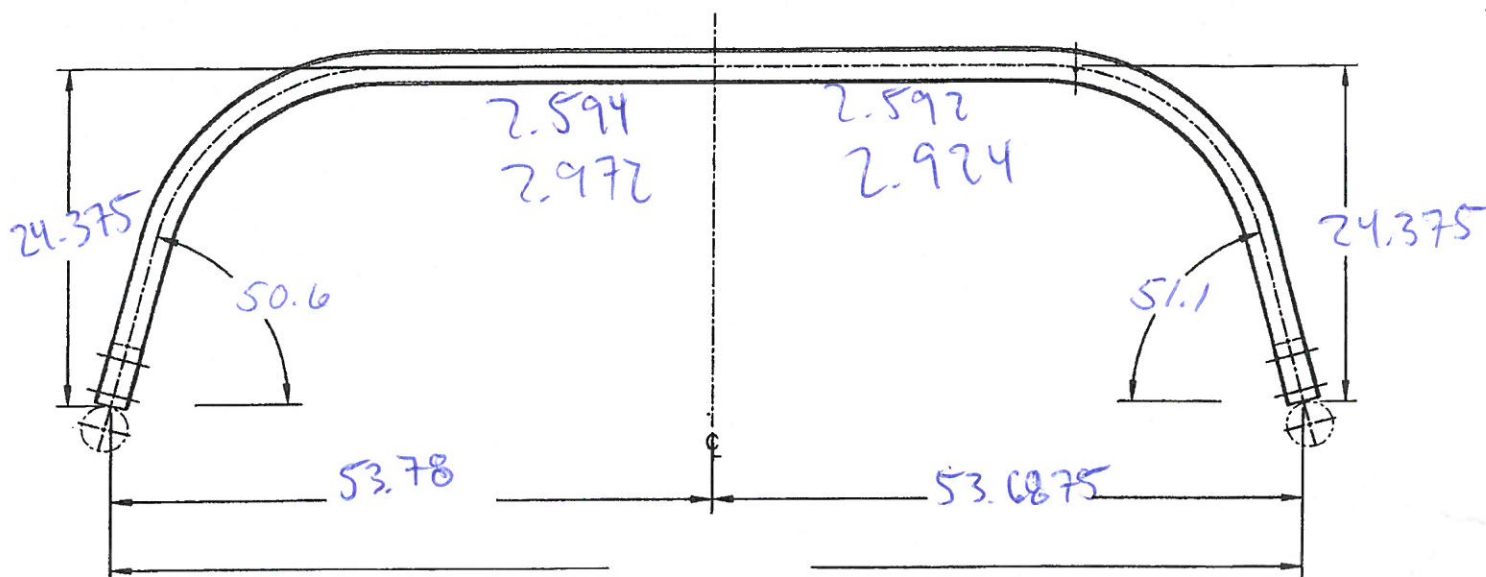
Specifications could not be found.

Plex 11/6/18 12:44 PM dart.white.jesse

14004512

DART AEROSPACE LTD		Work Order:	
Description: Crosstube High Aft (412)		Part Number:	D412-664-403
Inspection Dwg: D412-664-443 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	24.12	24.62
1/2 Span	53.56	53.82
Angle	49°	52°
Total Span	107.12	107.64
Bending Passes	8	--
Crushing	--	7%



	Side A	Side B
Bending Passes	7	7
Crushing	6.8%	6.7%
Comments		

QC15 Inspection	2B
Date	18-12-04

Rev	Date	Change	Revised by	Approved
A	14.07.08	New Issue	KJ	UP

Item	Qty	Part Number	Description
1	X	D412-864-443	CROSSTUBE ASSEMBLY (412 HI AFT)
2	1	D6020-132	CROSSTUBE MATERIAL
3	2	D4910-1	CHAFING SHIELD
4	1	D5380-1	SUPPORT
5	1	D5380-3	SUPPORT BASE
6	4	MS21920-26	CLAMP
7	8	NAS1805-4P	NUT
8	8	NAS6704-21	BOLT
9	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD
10	A/R	PROSEAL 890 OR 1422	SEALANT

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6020-132
- 2) FINISH: FINISHED LENGTH = 130.10±0.060 (BEFORE BENDING/TRIMMING)
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.1.4
APPLY MATTE CLEAR COAT TO UNDERSIDE OF CROSSTUBE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2, HATCHED AREA)
PAINT OUTSIDE PER DART QSI 005 4.2
AFTER PAINTING, REMOVE MASKING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PIN "D412-864-443" AND B/N ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 87.8 lb FINISHED WEIGHT
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

BENDING

- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7% (BASED ON O.D.) IN LOWER HALF OF R35 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038. TO BE PERFORMED AFTER FINAL POST-BEND GRINDING. ANY ADDITIONAL GRINDING REQUIRES ANOTHER LPI INSPECTION.

ASSEMBLY

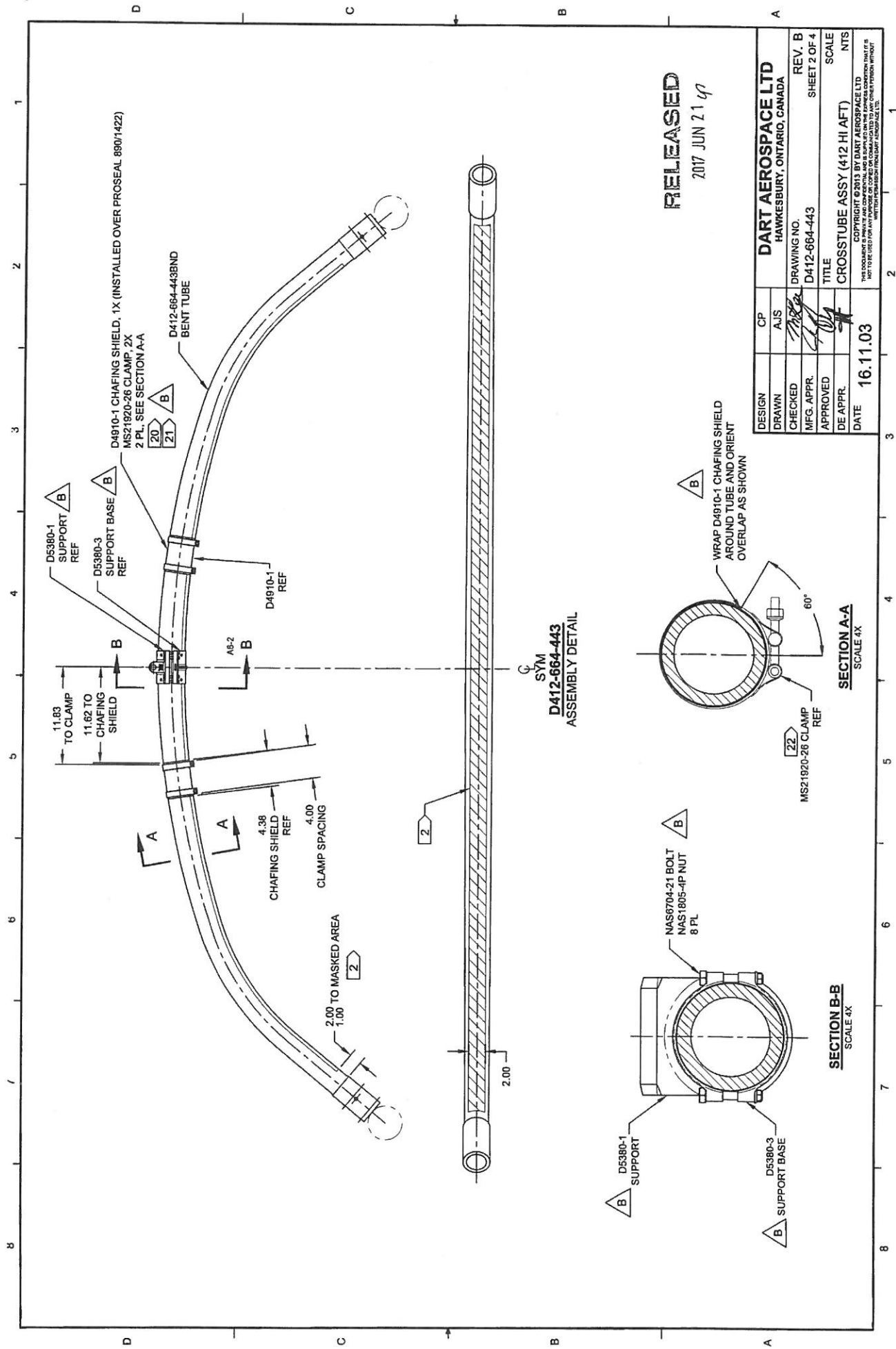
- 12) LOCATE THE D5380-1/3 SUPPORTS ONTO THE CROSSTUBE AS SHOWN IN THE ASSEMBLY DETAIL.
- 13) ABRASE THE MATING SURFACES OF THE CROSSTUBE AND D5380-1/3 SUPPORT HALVES WITH 180-GRIT SANDPAPER. SATURATE A CLEAN CLOTH WITH MEK, 4105S WASH/WIPE DEGREASER OR EQUIVALENT AND WIPE CLEAN UNTIL THERE IS NO RESIDUE.
- 14) APPLY A 0.04" TO 0.07" THICK LAYER OF 3M DP460 ADHESIVE ONTO THE CONCAVE SURFACE OF THE D5380-1 SUPPORT AND THE D5380-3 SUPPORT BASE.
- 15) INSTALL D5380-1 SUPPORT ONTO THE CROSSTUBE AS SHOWN IN THE ASSEMBLY DETAIL AND INSTALL QTY (2) NAS8704-21 BOLTS INTO OPPOSING CORNERS OF THE D5380-1 SUPPORT. ALIGN THE BOLTS WITH THE HOLES ON D5380-3 SUPPORT BASE AND INSTALL ONTO THE CROSSTUBE.
- 16) INSTALL THE REMAINING QTY (6) NAS8704-21 BOLTS AND QTY (8) NAS1805-4P NUTS. THEN EVENLY TORQUE THE NUTS IN A CRISS-CROSS PATTERN TO 50-70 IN-LBS. ENSURE A MINIMUM OF 1.5 THREADS ARE IN SAFETY.
- 17) WIPE OFF EXCESS ADHESIVE USING A CLEAN CLOTH SATURATED WITH MEK, 4105S WASH/WIPE DEGREASER OR EQUIVALENT.
- 18) ALLOW DP460 ADHESIVE TO CURE FOR 24 HOURS.
- 19) FILLET SEAL THE EDGES OF THE D5380-1/3 SUPPORT HALVES WITH PROSEAL PR1422 B12 OR PR890 B12 ALLOW PROSEAL TO CURE FOR 24 HOURS.
- 20) IF NOT ALREADY PRESENT ON D4910-1 CHAFING SHIELD, APPLY A 0.015" TO 0.020" THICK COAT OF PROSEAL 880/1422 ON INSIDE CONCAVE SURFACE OF D4910-1 CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS.
- 21) RECOAT THE D4910-1 CHAFING SHIELD WITH 0.015" TO 0.020" OF PROSEAL 880/1422 AND IMMEDIATELY INSTALL ONTO THE CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS. ENSURE THE D4910-1 CHAFING SHIELDS ARE WRAPPED TIGHTLY.
- 22) TORQUE CLAMPS ON D4910-1 CHAFING SHIELD 40 TO 50 IN-LBS. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON MS21920-26 CLAMPS AFTER ADHESIVES HAVE CURED FOR 24 HOURS.

ADD ITEMS 4, 5, 7, AND 8. DELETED ITEMS D4909-1, MS21920-28 & D5380-063-530. NOTE 2 UPDATED FOR TUBE FINISH. ALL ASSEMBLY NOTES REWRITTEN. SHEET 2 SECTION A-A ANGLE DIM ADDED FOR CHAFING SHIELD INSTALLATION. ASSEMBLY DETAIL AND SECTION B-B UPDATED FOR INSTALLATION OF D5380-1/3.		AJS		16.11.03
B				
A	NEW ISSUE	CP	BY	DATE
REV.	DESCRIPTION			
DESIGN	CP	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	DRAWING NO.		REV. B	
MFG. APPR.	D412-864-443		SHEET 1 OF 4	
APPROVED	TITLE		SCALE	
DE APPR.	CROSSTUBE ASSY (412 HI AFT)		NTS	
DATE	16.11.03			

RELEASED

2017 JUN 21
ECN 17-563

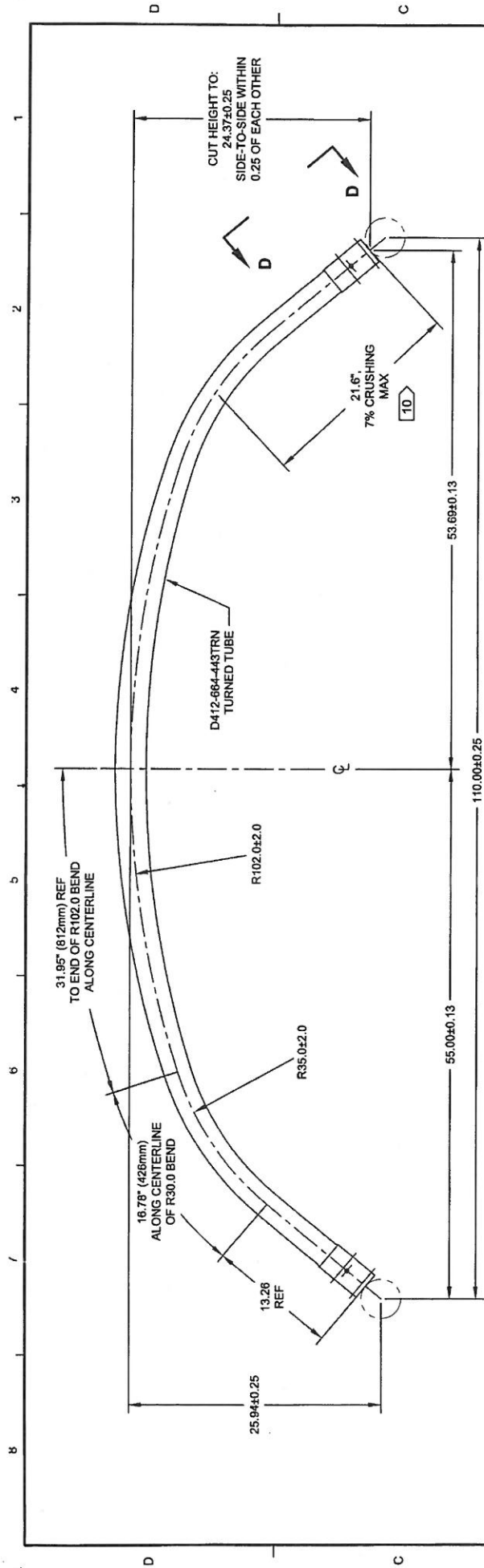
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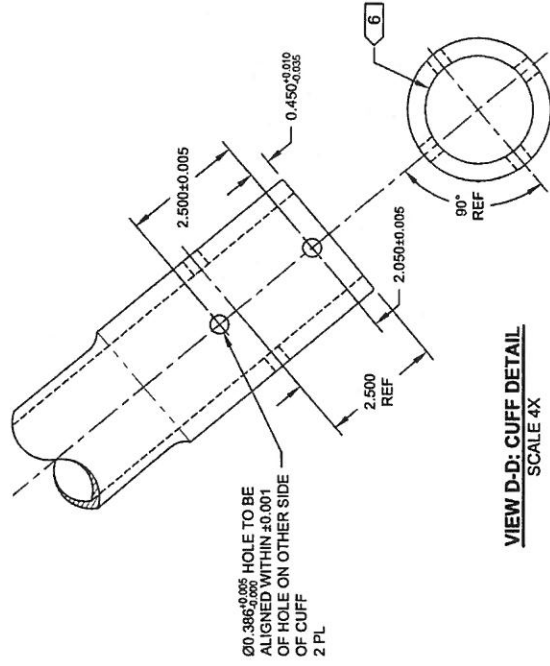
RELEASED
2017 JUN 21 47

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CHECKED	MSB	DRAWING NO.
MFG. APPR.	MSB	D412-664-443
APPROVED	MSB	REV. B
DE APPR.	MSB	SHEET 2 OF 4
DATE	16.11.03	TITLE
		CROSSTUBE ASSY (412 HI AFT)
		SCALE
		NTS

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D412-664-443BND
BENDING DETAIL



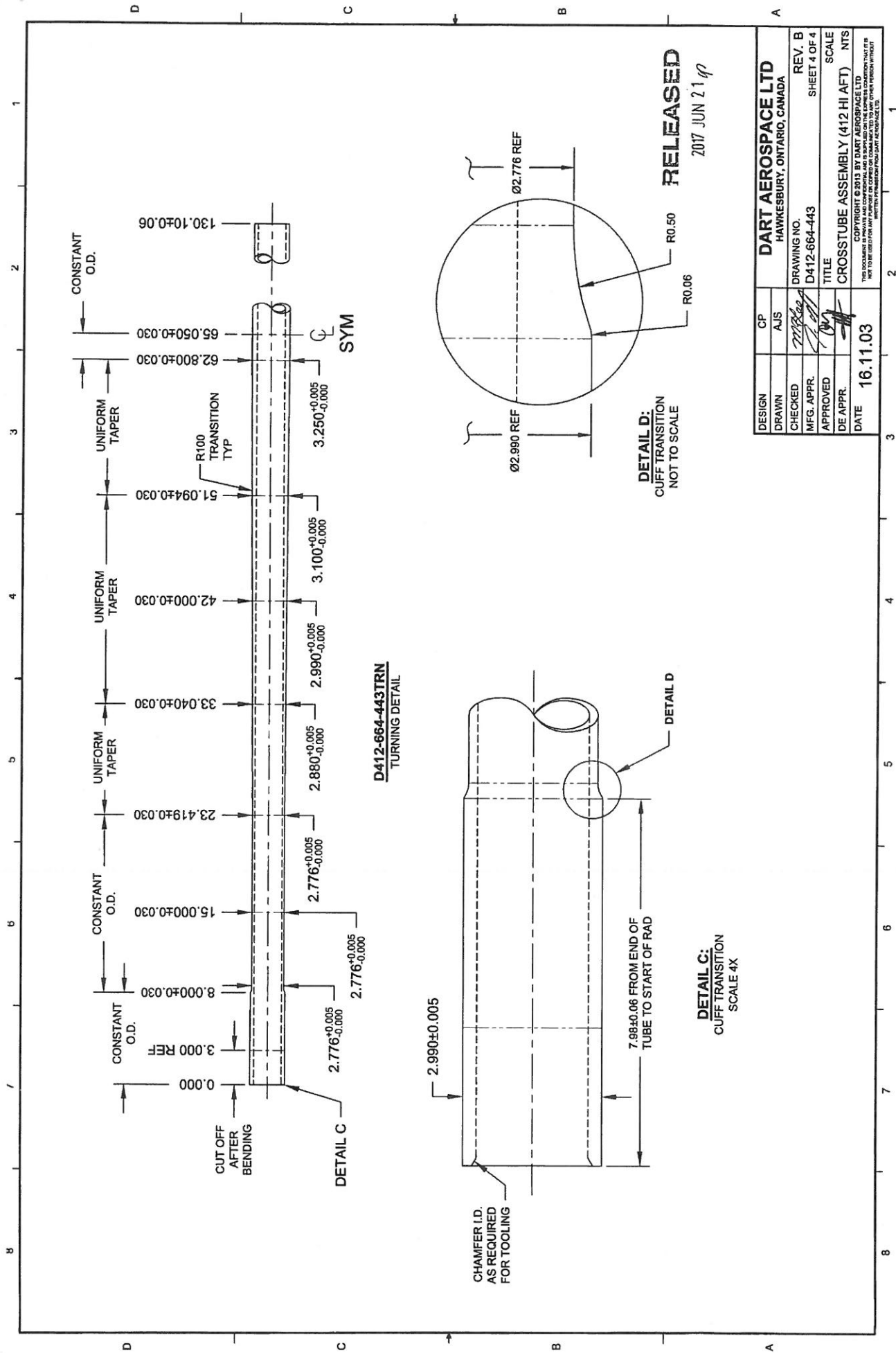
VIEW D-D: CUFF DETAIL
SCALE 4X

RELEASED

2017 JUN 21st

DESIGN	CP	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	MZ	DRAWING NO. REV. B
MFG. APPR.	D412-664-443	SHEET 3 OF 4
APPROVED	DE	TITLE SCALE
DE APPR.	16.11.03	CROSSTUBE ASSY (412 HI AFT) NTS
DATE	16.11.03	COPYRIGHT © 2013 BY DART AEROSPACE LTD

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D412-664-443TRN
TURNING DETAIL

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2017 JUN 21 17

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. B
MFG. APPR.	<i>[Signature]</i>	D412-664-443 SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE ASSEMBLY (412 HI AFT) NTS
DATE	16.11.03	COPYRIGHT © 2013 BY DART AEROSPACE LTD

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041972**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041972
PO Date: 12/6/18
Due Date: 12/14/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184179	D4464-041	Fuel Tank Assembly - Various STC's ISSUE P/O LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	12/14/18	1 pcs	0 pcs	1 pcs	\$227.00/pcs	\$227.00
2	185376	D212-664-101	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	12/14/18	1 pcs	0 pcs	1 pcs	\$227.00/pcs	\$227.00
	187043			Firmed	-	12/14/18	1 pcs	0 pcs	1 pcs	\$227.00/pcs	\$227.00
Sub Total:							2	0	2		\$454.00
3	185903	D412-664-403	412 Stainless Steel Aft Crosstubes - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17	Firmed	-	12/14/18	1 pcs	0 pcs	1 pcs	\$227.00/pcs	\$227.00
	186496			Firmed	-	12/14/18	1 pcs	0 pcs	1 pcs	\$227.00/pcs	\$227.00

Plex 12/7/18 8:54 AM dart.tsimiklis.chrisoula



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041972**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Sub Total:							2	0	2		\$454.00
Grand Total:											\$1,135.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/7/18 8:54 AM dart.tsimiklis.chrisoula

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

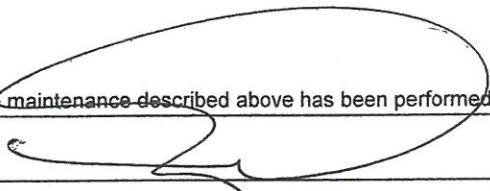
WO #: MWO38511	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO041972
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:**CARRY OUT NDT ON:**

- ✓ 1 FUEL TANK ASSY , P/N# D4464-041 , J/S# 184179 ✓
- ✓ 2 FWD CROSSTUBES , P/N# D212-664-101 , J/S# 185376 , 187043 ✓
- ✓ 2 AFT CROSSTUBES , P/N# D412-664-403 , J/S# 185903 , 186496 ✓

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16						DEC 06 2018	  DAS 38 9-89
NO CRACK FOUND							
3 LEAKS FOUND IN FUEL TANK							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142							
<i>Description</i>	<i>Location</i>	<i>P/N</i>	<i>Qty</i>	<i>Batch</i>	<i>S/N Off</i>	<i>S/N On</i>	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: DEC 06 2018
Name: RAFIK MELIKIAN		

Change Record

PAGE 1 OF 1

Part Number: D412-664-403

Description: CROSSTUBE INSTALLATION, HEAVY DUTY, HIGH AFT

[illegible]

